Work Order ID 51783

Thursday, September 03, 2009 8:16:20 AM

Item ID: D350-591-312 **Accept** **Setup Start**

Revision ID: B **Stop**

Item Name: Heli-Access-Step, Long RH

Start Date: 9/3/2009 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 9/25/2009 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** RL MK **Date:** 9-9-09 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3272	Rev B								
100	DOCUMENT CONTROL	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-312 CHG001								
110	Large Fab	0.00				10	0		
Large Fab	**Memo**	0.00							
Large Fab	1-Bevel end for welding FWD ONLY MK 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 MK 09.09.22 A/R Aluminum Rod m111311 m111494 3-Grind End Plate flush MK								

MJ for BG 09/09/28

DC 09/09/30

Work Order ID 51783

Thursday, September 03, 2009 8:16:20 AM

Item ID: D350-591-312 **Accept** **Setup Start** **Stop**

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 9/3/2009 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 9/25/2009 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00				~~10~~	~~0~~	~~BE 09/09/22~~	
QC	**Memo**	0.00				10	0	BE 09/09/22	
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							
		2) 0 09/09/22							
QC	**Memo**	0.00				+10RH	0		
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
		BR 09-09-22							
HandFinish	**Memo**	0.00				10RH			
Hand Finishing									

Work Order ID 51783

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Item ID: D350-591-312 **Accept** **Setup Start**

Revision ID: B **Stop**

Item Name: Heli-Access-Step, Long RH

Start Date: 9/3/2009 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 9/25/2009 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00	09.09.23			10	ϕ		
QC	**Memo**	0.00							
Quality Control									
160		0.00							
Large Fab	Large Fab								
Large Fab	**Memo** Assemble Leg Assembly as per Dwg D3272.	0.00	09.09.24			10	ϕ		
170	QC5- Inspect part completeness to step on W/O	0.00	N/A						
QC	**Memo**	0.00							
Quality Control	09.09.22								

Work Order ID 51783

Thursday, September 03, 2009 8:16:20 AM

Item ID: D350-591-312 **Accept** **Setup Start** **Stop**

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 9/3/2009 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 9/25/2009 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Large Fab	0.00				10	0		
Large Fab									
Large Fab	**Memo**	0.00							
	1-Bevel Aft end for welding								
	2-Inspect for foreign object as per QSI 024								
	3-Weld Aft End Plate as per QSI 004 & DwgD3272								
	A/RAluminum Rod m11311								
	4-Grind End Plate flush								
	5-Install last rivet.								
190	QC9- Inspect visual per QSI004- Fusion Welds	0.00				10	0	RE 09/09/24	
QC	**Memo**	0.00							
Quality Control									

Work Order ID 51783

Thursday, September 03, 2009 8:16:20 AM

Item ID: D350-591-312 **Accept** **Setup Start** **Stop**

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 9/3/2009 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 9/25/2009 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				X10RH	0		
210 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				X10RH	0		
220 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M1122760 Memo START TIME: 8:00Am OVEN TEMPERATURE: 320°F FINISH TIME: 8:30Am	0.00 0.00				X10RH	0		

Work Order ID 51783

Thursday, September 03, 2009 8:16:20 AM

Item ID: D350-591-312 **Accept** **Setup Start** **Stop**

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 9/3/2009 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 9/25/2009 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Wing Walk as per dwg QSI005 4.4 Batch M112106	0.00	bl 09-09-29			(10)			
HandFinish	**Memo**	0.00							
Hand Finishing									
240	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									
250	Pick Kit	0.00							
Packaging	**Memo**	0.00							
Packaging									

9/9/09 (10) SH

Work Order ID 51783

Thursday, September 03, 2009 8:16:20 AM

Item ID: D350-591-312 **Accept** **Setup Start**

Revision ID: B **Stop**

Item Name: Heli-Access-Step, Long RH

Start Date: 9/3/2009 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 9/25/2009 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC4- 100% Inspect kits for completeness	0.00							
QC	**Memo**	0.00							
Quality Control									
270		0.00							
Packaging	Packaging								
Packaging	**Memo**	0.00							
	Identify and pack for shipping as per PPPD350-591-312 Location:								
280	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

Picklist Print

Thursday, September 03, 2009 8:16:34 AM

T2

Work Order ID: 51783

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/25/2009

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3067-1RevA End Plate		Manufactured	No			110	Each	35.0000	10.0000		09-09-14	

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST 351546	35	
51104	35	

ID

D3272-1RevB Step		Manufactured	No			110	Each	0.0000	10.0000	351899	09-09-14	
MS21042L5 ×2 Nut		Purchased	No			110	Each	1,363.000	20.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1363	
110382	10	
111636	353	
112314	1000	

111636 9/9/28 (100) SC

Picklist Print

Thursday, September 03, 2009 8:16:34 AM

Work Order ID: 51783

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/25/2009

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3065-041RevB		Manufactured	No			160	Each	42.0000	10.0000		09-09-23	
Step Leg Assembly Hi												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	22		
No more → 50095	2		
51125	20	09-09-23	10
Main Warehouse			
WA	20		
50095	20		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3066-1RevB		Manufactured	No			160	Each	40.0000	20.0000		09-09-23	
Spacer												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST B51545	40		20
50383	40		

Picklist Print

Thursday, September 03, 2009 8:16:34 AM

Work Order ID: 51783

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/25/2009

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3219-1RevA Plate		Manufactured	No			160	Each	61.0000	20.0000		09.09.22	

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	61		
47296	17		10
51186	44		10

Scrap 1 part 351186

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W4 Rivets		Purchased	No			180	Each	2,999.000	160.0000		09.09.23	

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	2999		
110731	215		
111359	46		
111477	74		
112082	264		
112314	2000		
112385	400		160

09.09.23

Picklist Print

Thursday, September 03, 2009 8:16:34 AM

Work Order ID: 51783

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/25/2009

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-35A x2		Purchased	No			260	Each	541.0000	20.0000			
Bolt												

6+10

9/9/28 TDS

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	541		
106993	12		
110467	29		
112314	500		112314

Picklist Print

Thursday, September 03, 2009 8:16:34 AM

Work Order ID: 51783

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/25/2009

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-13A KB		Purchased	No			260	Each	919.0000	80.0000		9/4/08 KDL	
Bolt												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
Return 2009	8		
111477	8		
Main Warehouse			
ST	911		
107321	1		
107534	5		
107959	23		
109285	37		
110552	66		
110865	3		
111477	9		
111925	7		
112314	760	112314	54
17406	0		

Picklist Print

Thursday, September 03, 2009 8:16:34 AM

Work Order ID: 51783

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 9/3/2009 **Required Date:** 9/25/2009

Comments:

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-36A x2		Purchased	No			260	Each	611.0000	20.0000			
Bolt												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	611			
109545	11			
110467	7			
110731	4			
112243	39			
112314	500		112314	SA
112385	50			

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10 x4		Purchased	No			260	Each	2,357.000	40.0000		9/9/08 (10x)	
Washer												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	2357			
105442	95			
109059	2			
109840	23			
110985	202			
111279	13			
111668	22			
112314	1000			
112369	1000		112369	SA

Picklist Print

Thursday, September 03, 2009 8:16:34 AM

Work Order ID: 51783

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 9/3/2009 **Required Date:** 9/25/2009

Comments:

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416 Washer		Purchased	No			260	Each	9,093.000	160.0000		9/9/28	

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
Return 2009	18		
111279	18		
Main Warehouse			
ST	9075		
102929	2		
105906	4		
107321	23		
107939	114		
108161	553		
108827	31		
109249	69		
110523	340		
111279	101		
111916	2951		111916 SP
112314	4887		
16941	0		

Picklist Print

Thursday, September 03, 2009 8:16:34 AM

Work Order ID: 51783

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 9/3/2009 **Required Date:** 9/25/2009

Comments:

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516 Washer		Purchased	No			260	Each	1,257.000	40.0000			
D2230-3RevG Lug		Manufactured	No			260	Each	0.0000	40.0000			

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	1257		
100564	2		
106167	6		
107534	34		
107959	43		
108246	46		
108672	2		
109059	49		
109752	22		
110363	46		
110523	57		
111279	43		
112082	407		112082 SP
112314	500		

Picklist Print

Thursday, September 03, 2009 8:16:34 AM

Work Order ID: 51783

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 9/3/2009 **Required Date:** 9/25/2009

Comments:

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2618RevB1 x2		Manufactured	No			260	Each	371.0000	20.0000			
Bushing												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST039	20	
50659	20	
Main Warehouse		
ST39	351	
50989	200	
51189	151	

51189 50

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2856-400RevA x2 @ 7.2"		Manufactured	No			260	f	336.2077	6.0000			
Abraison Strip												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	122.8077	
42437	44.93	
46543	77.8777	
Main Warehouse		
ST403	212.15	
50593	212.15	

50593 9/9/28 (10) S6

Picklist Print

Thursday, September 03, 2009 8:16:34 AM

Work Order ID: 51783

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/25/2009

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3067-1RevA End Plate		Manufactured	No			260	Each	35.0000	10.0000		09.09.22	

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST 351546	35		10
51104	35		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3235-1RevA +2 Mounting Lug		Manufactured	No			260	Each	213.0000	20.0000		9/9/28 (10) SP	

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	213		
45398	4		
46745	109		46745
47969	100		

Picklist Print

Thursday, September 03, 2009 8:16:34 AM

Work Order ID: 51783

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/25/2009

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3278-041RevC		Manufactured	No			260	Each	60.0000	10.0000			
Support Assembly												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	20		
47886	20		
Main Warehouse			
ST471	40		
51191	40		51191 54

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			260	Each	3,808.000	20.0000		9/9/28 (10)	
Nut												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	3808		
110844	32		
111274	284		111274 50
111668	992		
112314	2000		
112385	500		

Picklist Print

Thursday, September 03, 2009 8:16:34 AM

Work Order ID: 51783

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 9/3/2009 **Required Date:** 9/25/2009

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4 +6		Purchased	No			260	Each	8,411.000	80.0000		9/9/08	TDR SO
Nut												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	8411		
107499	5		
110507	369		
111827	5996		
112314	2000		112314
15924	0		
8182	41		

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS

A	04.03.01	NEW ISSUE
B	07.05.18	D3272-1 WAS D2622-120

RELEASED
07 06 04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		**D3272-041**	**STEP ASSEMBLY, HIGH LONG (LH)**
	X	**D3272-042**	**STEP ASSEMBLY, HIGH LONG (RH)**
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

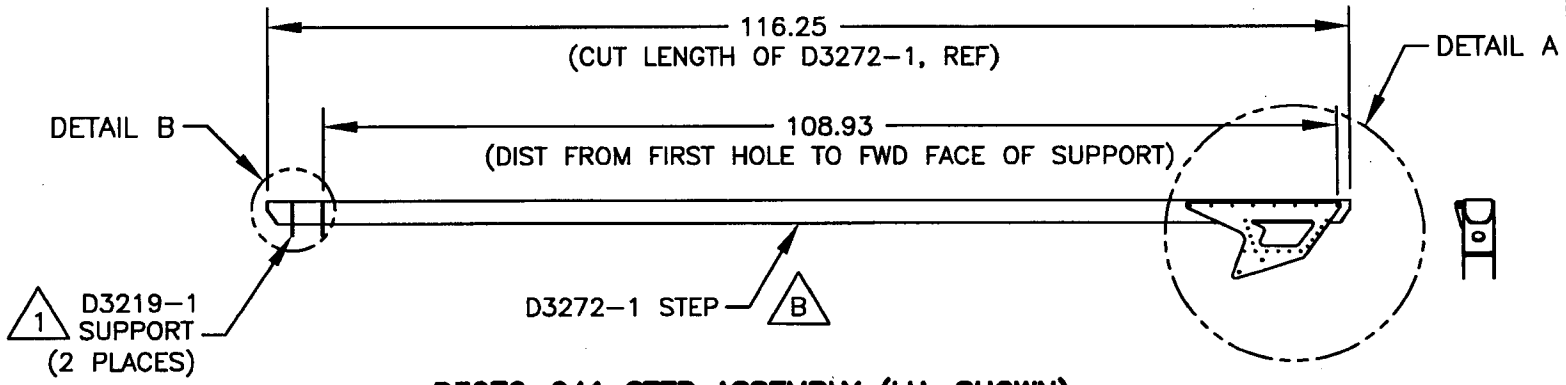
B

S1783

GENERAL NOTES:

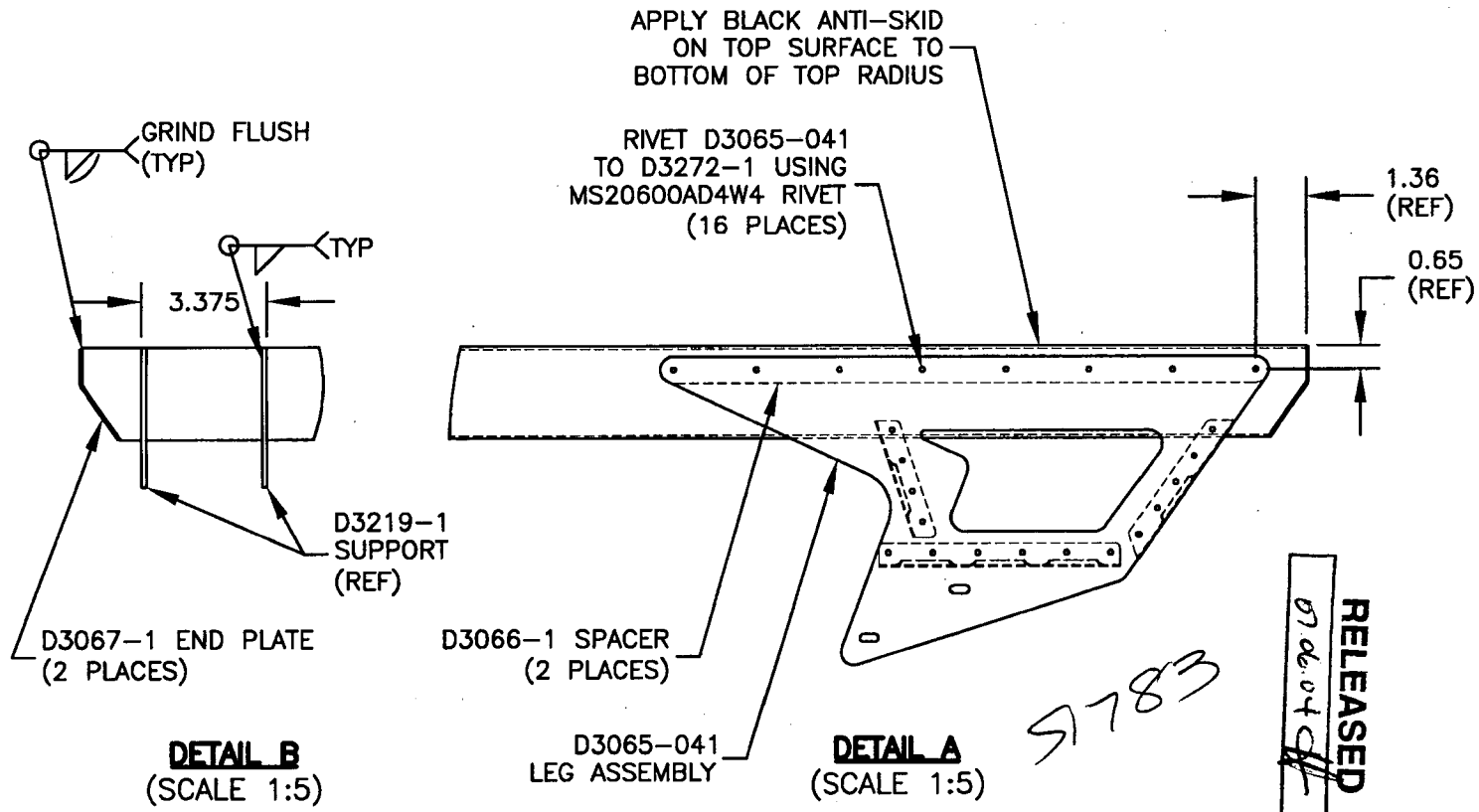
1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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D3272-041 STEP ASSEMBLY (LH, SHOWN)

D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



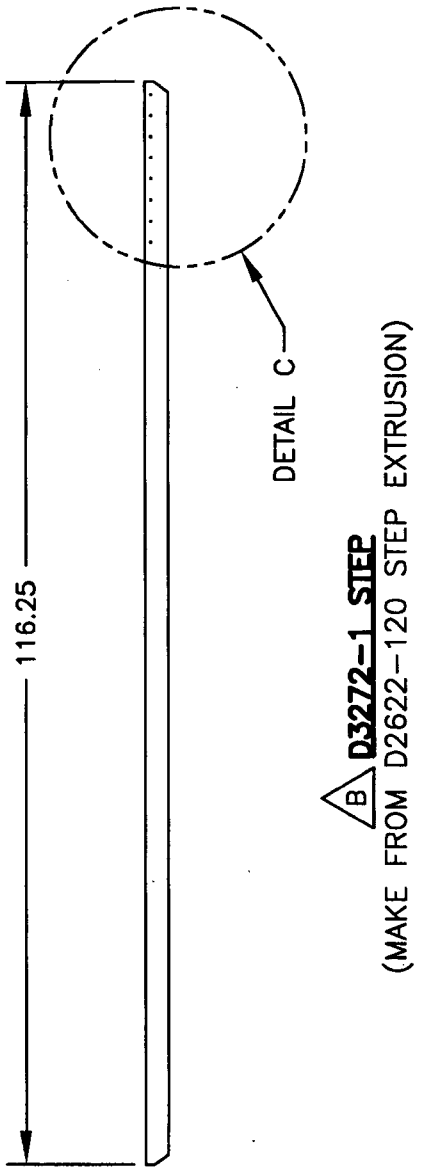
DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	DRAWING NO. D3272	REV. B
		SCALE 1:20	SHEET 2 OF 3

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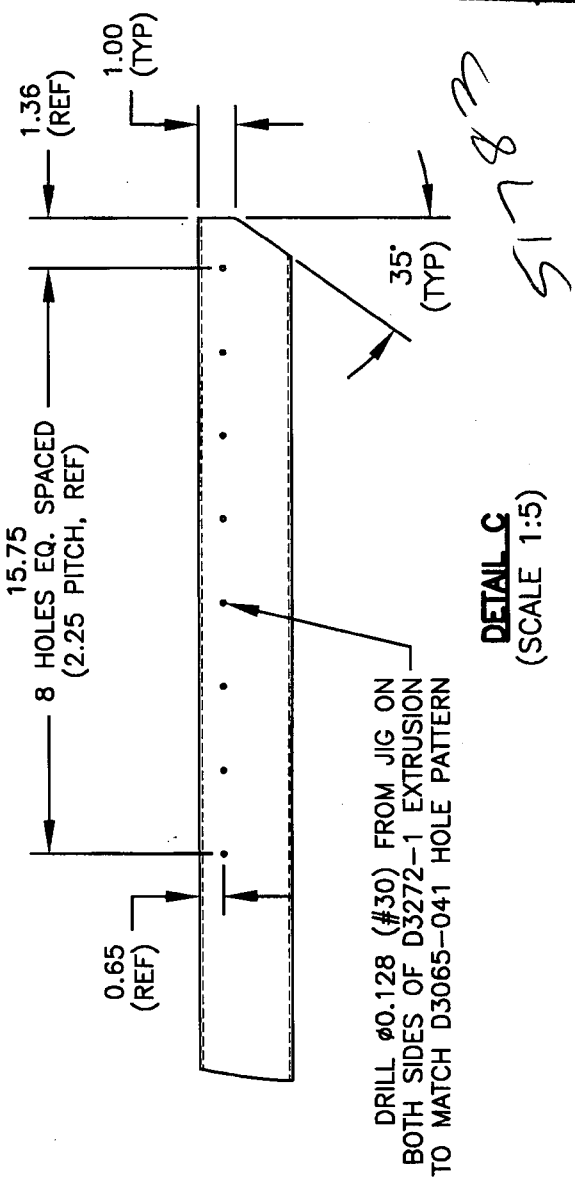
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CHECKED	APPROVED	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED
07.06.04



(B) D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	***Heli-Access-Step***™, Long Step – High Skid, LH
	X							D350-591-212	***Heli-Access-Step***™, Long Step – High Skid, RH
		X						D350-591-213	***Heli-Access-Step***™, Short Step – High Skid, LH
			X					D350-591-214	***Heli-Access-Step***™, Short Step – High Skid, RH
				X				D350-591-215	***Heli-Access-Step***™, Short Step – Low Skid, LH
					X			D350-591-216	***Heli-Access-Step***™, Short Step – Low Skid, RH
						X		D350-591-311	***Heli-Access-Step***™, Long Step – High Skid, LH
							X	D350-591-312	***Heli-Access-Step***™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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